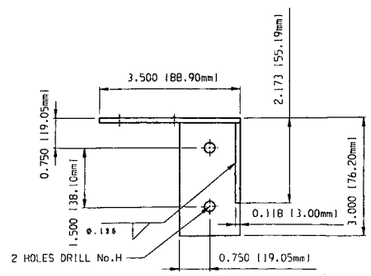
REVISION TABLE			
REV	DRAWING No.	DATE	DESCRIPTION
A	BHA/DRA/358-04-01	12/11/90	ORIGINAL ISSUE
B	BHA/DRA/358-04-01	.	DWG CHANGES
C	BHA/DRA/358-04-01	19/6/92	BHP EO 1007
D	BHA/DRA/358-04-01	.	BHP EO 1013
E	BHA/DRA/358-04-01	17/06/96	CONSOLIDATION
F	BHA/DRA/358-04-01	15/04/98	ECR-33
G	BHA/DRA/358-04-01	20/8/98	ECR-60 - CORRECT SCALE

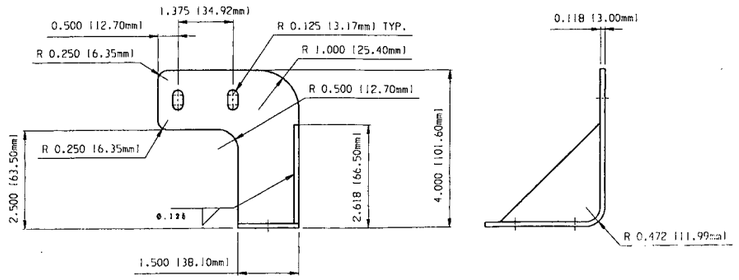
1: ALL WELDING TO BE TIG PROCESS USING 4043 FILLER WIRE. WELD DISTANCES IN INCHES.

2: PRIOR TO WELDING REMOVE OXIDE COAT WITH STAINLESS STEEL WIRE BRUSH.

3: COMMERCIAL MATERIAL MUST BE SUPPLIED UNDER COVER OF N.A.T.A. CERTIFICATE FOR CHEMICAL PROPERTIES AND HARDNESS TO AS1734-1986 FOR SHEET & PLATE & TO AS1866-1986 FOR EXTRUSIONS.

4: VISUALLY CHECK FOR CORROSION PITTING, STRAIGHTNESS AND FREEDOM FROM KINKS, DENTS & HEAVY SCRATCHING.

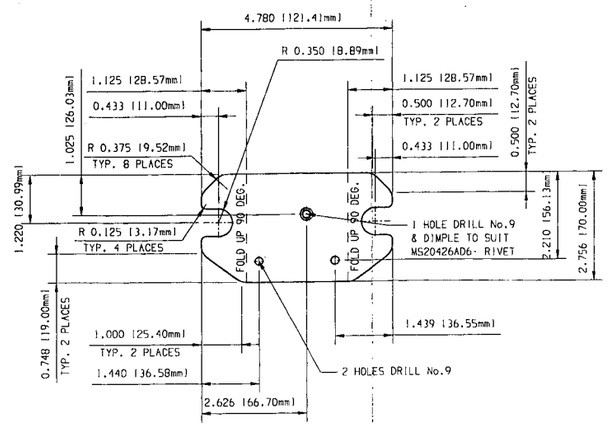


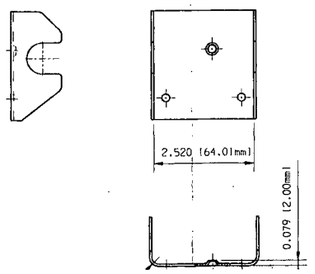


DETAIL OF PART No. 358-029-001 (37)

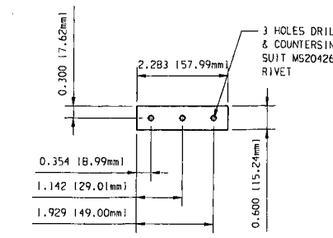
DETAIL OF PART No. 358-028-001 (36)

MIRROR IMAGE OF PART No. 358-029-001

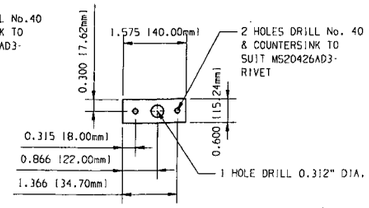




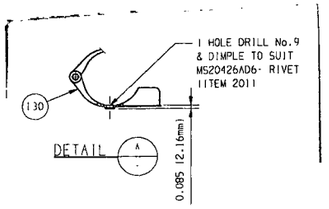
DETAIL OF PART No. 358-092-001 (104)

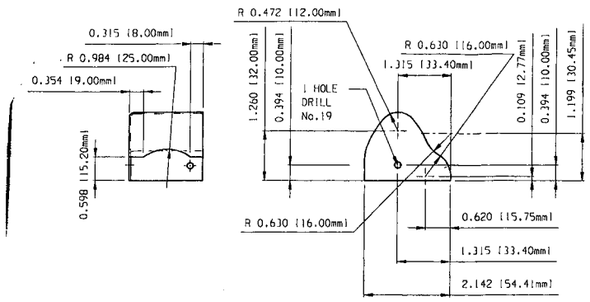


DETAIL OF PART No. 358-091-001 (103)

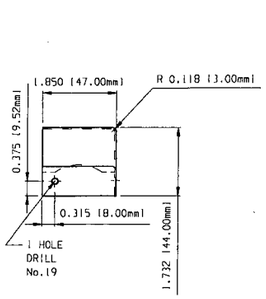


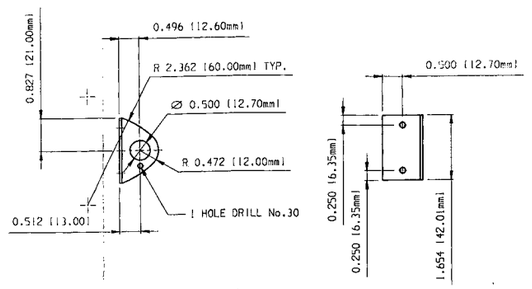
DETAIL OF PART No. 358-090-001 (102)





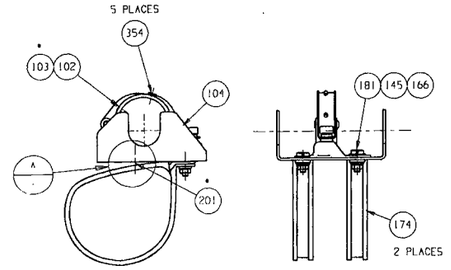
DETAIL OF PART No. 358-073-001 (83)





DETAIL OF PART No. 358-072-001 (82)

DETERMINE EXACT DIMENSIONS ON ASSEMBLY WITH ITEM 83



DETAIL OF PART No. 358-062-001 (72)

NOTE: "*" INDICATES PART NOT SHOWN.

ITEM	QTY	SW QTY	PART NUMBER	DESCRIPTION	MATERIAL-ORIGINAL P/N	SIZE	GRADE	MAT.SPEC.	INIT. TREATMENT	FINAL TREATMENT	MASS
104	1		358-092-001	LOCKING SUPPORT	0.050" THICK ALUM. ALLOY SHEET		2024	00-A-250/3	T3		
103	2		358-091-001	PACKER	0.075" THICK POLYCARBONATE						
102	2		358-090-001	PACKER	0.075" THICK POLYCARBONATE						
83	1		358-073-001	SWITCH COVER	BI DIRECTIONAL FIBREGLASS						
82	1		358-072-001	SWITCH BRACKET	25.0x25.0x1.6mm ALUM. ALLOY SQU. ANG.		2024	00-A-250/5	T3		
72	2		358-062-001	COUPLING BRACKET	ASSY OF ITEMS						
37	1		358-029-001	VALVE BRACKET RH	3.0mm THICK ALUM. ALLOY SHEET		5005	COMM	H34		
36	1		358-028-001	VALVE BRACKET LH	3.0mm THICK ALUM. ALLOY SHEET		5005	COMM	H34		

REFERENCE DRAWINGS	
BHA/DRA/358-01-01	MATERIALS LIST
BHA/DRA/358-01-02	MATERIALS LIST (CONTINUED)

MANUFACTURING OPERATIONS

ALL DIMENSIONS TO BE MET AFTER PLATING.
REMOVE ALL BURRS:
BREAK ALL SHARP EDGES 0.015"-0.031" 0.4mm-0.8mm

TOLERANCE (Except where otherwise stated)

Over	Up To	Tolerance
0	0.400	0.005
0.400	2.0	0.008
2.0	6.0	0.014
6.0 & OVER		0.020

ANGULAR TOLERANCE (U.N.O) +/- 0.5°

SURFACE ROUGHNESS U.N.O INCLUDING REAMED HOLES FOR DRILLED HOLES

BEND RADIUS

CORNERS AND FILLETS

MARK PART # IN REGION MARKED:

WELDING
ALL WELDING FULL PENETRATION
A 3mm BEAD MUST REMAIN ON AT LEAST ONE SIDE U.N.O

MATERIAL

MATERIAL

TREATMENT:
REFER BHT-ALL-SPM PARAGRAPH 4-5 -> 4-15 FOR SURFACE PREPARATION & PAINTING

DIMENSIONS IN INCHES (mm)

APPROVED pursuant to a direction given by Regulation 35 of the Civil Aviation Regulations on
date: 1-9-98
signature:
name: C.W. WHITNEY
being an Authorised Person for and on behalf of Helitech Pty Ltd
Certificate of Approval 3300
A.C.N. 010 600 987

Helitech PTY LTD
BRISBANE HELIPORT
LAMINGTON AVE. EAGLEFARM
Incorporated in Queensland
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AS 1100

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DRAWN	NORA KINNUNEN
DATE	20/8/98
SCALE	1:2
CHECKED BY	C.W.WHITNEY
DATE PLOTTED	20/8/98

Client: HELITECH PTY. LTD.

Title: KWIK FLOAT INSTALLATION
PARTS DETAIL
BELL 206 A & B SERIES

IRN	CI	Drawing Number	Revision
329	117, 118	BHA/DRA/358-04-01	G